

CLAIMS

1. A method for manufacturing knitted articles for forming items of clothing, such as body suits, sleeveless tops, undershirts, bras, underpants or the like, without lateral seams, with a circular knitting machine, characterized in that it comprises a step for forming at least one pouch-like region (13a,13b,23a,23b,25a,25b) in which part of the needles or all the needles that belong to at least one sector of the needle cylinder are moved to knit at at least one feed of the machine by actuating the needle cylinder of the machine with an alternating rotary motion about the axis thereof and with an extent of oscillation that is sufficient to make transiting, at said at least one feed, all the needles of said at least one sector that are moved for knitting at said at least one feed, in order to form, with the needles that belong to said at least one sector and are moved for knitting, a number of rows of knitting in excess with respect to the number of rows of knitting formed by the needles that are contiguous to said at least one sector.

2. The method according to claim 1, characterized in that during said step for forming pouch-like regions (13a,13b,23a,23b,25a,25b), rows of knitting are also formed by making all or part of the needles distributed along the entire circumferential extension of the needle cylinder knit at said at least one feed.

3. The method according to claim 1, characterized in that during said step for forming pouch-like regions (13a,13b,23a,23b,25a,25b) the number of needles that belong to said sector and are moved to knit at the corresponding feed is increased gradually.

4. The method according to claim 1, characterized in that during said step for forming at least one pouch-like region (13a,13b,23a,23b,25a,25b) the number of needles that belong to said sector and are moved to knit at the corresponding feed is decreased gradually.

5. The method according to one or more of the preceding claims, characterized in that during said step for forming at least one pouch-like

region (13a,13b,23a,23b,25a,25b) the number of needles that belong to said sector and are moved so as to knit at the corresponding feed is first increased gradually and then decreased gradually.

6. The method according to one or more of the preceding claims,  
5 characterized in that during said step for forming pouch-like regions (13a,13b,23a,23b,25a,25b) the number of needles that belong to said sector and are moved to knit at the corresponding feed is first decreased gradually and then increased gradually.

7. The method according to one or more of the preceding claims,  
10 characterized in that during said step for forming pouch-like regions (13a,13b,23a,23b,25a,25b) the number of needles that belong to said sector and are moved to knit at the corresponding feed is first decreased gradually, retaining the last formed loop of knitting in the hook of the needles that are gradually excluded from knitting, and is then increased gradually by  
15 resuming knitting also with the needles previously gradually excluded from knitting that had retained in their hook the last formed loop of knitting.

8. The method according to one or more of the preceding claims, characterized in that before said step for forming pouch-like regions (13a,13b,23a,23b,25a,25b), a step for forming at least one tubular portion of  
20 knitting is performed by moving so as to knit, at at least one feed or drop of the machine, all the needles or part of the needles of the needle cylinder distributed along the entire circumferential extension of the needle cylinder, and the needle cylinder is actuated with a continuous rotary motion about its own axis.

25 9. The method according to one or more of the preceding claims, characterized in that after said step for forming at least one pouch-like region (13a,13b,23a,23b,25a,25b), a step for forming at least one tubular portion of knitting is performed by moving so as to knit, at at least one feed or drop of the machine, all the needles or part of the needles of the needle  
30 cylinder distributed along the entire circumferential extension of the needle

cylinder, and the needle cylinder is actuated with a continuous rotary motion about its own axis.

10. The method according to one or more of the preceding claims, characterized in that at least part of said tubular portion of knitting (12) is  
5 produced as a double folded border.

11. The method according to one or more of the preceding claims, characterized in that said step for forming at least one pouch-like region (13a,13b,23a,23b,25a,25b) comprises the simultaneous production of at least two pouch-like regions, in which needles belonging to at least two  
10 sectors of the needle cylinder that are angularly spaced from each other around the axis of the needle cylinder are moved so as to knit at a different feed for each one of said sectors and the needle cylinder is actuated with an alternating rotary motion about its own axis with an oscillation extent that produces the transit, in front of the corresponding feed, of all the needles of  
15 the correlated sector that are moved so as to knit in order to form, with the needles that belong to said at least two sectors and are moved so as to knit at the corresponding feeds, rows of knitting in excess with respect to the rows of knitting formed, during said step for forming the pouch-like regions, by the needles that are contiguous to said at least two sectors.